

Date: Tuesday, 10/23/2007 3:10:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR
Job Number : 35321	
Estimate Number : 12424	
P.O. Number :	Part Number : D2000109
This Issue : 10/23/2007 S.O. No. :	Drawing Number : D2000-109 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A1
Previous Run : 27400	Material :
Written By :	Due Date : 11/15/2007 Qty: 10 Um: Each
Checked & Approved By : <u>107.10.23</u>	
Comment : Est Rev:A New Issue 06-05-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4889 For D2000-109

Spin as per Dwg D2000-109

Possible Supplier: SIEG

Material release note is required

07110124 10

2.0	D2000109S	Aspirator- Outer Flange
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

7/11/07 SC 10X

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

07110124 10

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Drill as per Dwg D2000

Deburr

FF 08-05-2110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:10:26 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 35321

Part Number: D2000109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/05/21 (410)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 162

8/5/21

(10x)

50

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/22

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W.H. GERRY



ALCOA INDIUM PRODUCTS
1480 Monheim Pike
Lancaster Pa 17601

Certification of Test Results

P/N 970200

PO 38C880

SOLD TO

SHIP TO

CERT NO 0000575996
DATE 4/23/2007
SKID NO 661032
SKID WGT 9,885
PAGE 1 OF 1

ORDER NO	LG5947	PO NO	43-62756			MILL FINISH
ITEM NO	1	PART NO				NON ANODIZE QUALITY
ALLOY	1100	TEMPER	O	FORM	COIL	OUT: STANDARD MILL FINISH
GAUGE	05300	WIDTH	48.0000	LENGTH	0.0000	IN: STANDARD MILL FINISH
						NOT EMBOSSED

LOT: 334171 COIL: B01 DROP: 0710187

INGOT	SI	FE	CU	NI	MG	CR	NI	ZN	TI
0718321	0.12	0.49	0.12	0.02	0.01	0.01	0.01	0.01	0.01

HEAD ULTIMATE STRENGTH 13.1 KSI
TAIL ULTIMATE STRENGTH 12.0 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI
HEAD ELONGATION (G.L. = 2 IN) 32 %
TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-05

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB069 1100 O, AMS 4001H 1100 O,
ASTM B209-05 1100 O, AMS-00 A 250/1 1100 O
PAX CERTS: 714-736-4040

** END OF CERTIFICATION **

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material and the composition. Also, note that we carry out a normal containment to aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. Certification of test results shall not be reproduced except in full.

This report is the property of the supplier and is loaned to the customer for their use only. It is not to be distributed outside the company. Reproduction is prohibited.

Authorized by:

JEFF KROBATH, LAB SUPERVISOR

Sold to: COPPER & BRASS SALES PO: 38C880 Part: Order No.: 376276

TR clerk signature

10 12:52 FAX

10011001



Sieg's Manufacturing Ltd.
6236 205 street, Langley BC, V2Y 1N7
Phone: (604) 530-7455 Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 34575
Date: 11/05/2007
Page: 1

Sold to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7		Ship to: DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7	
Order No.: 4888		Sold By: KAULBARS, GERRY	
Shipped By:		Ship Date: 11/06/2007	
Tracking No.:			

Item No.	Unit	Description	Quantity
1	EACH	D2000109S OUTER FLANGE	10
2	EACH	D2000111S INNER CORE	10
REFERENCE ONLY			
Comment:			



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Nov. 5/07
Customer: Dart Aerospace
Packing Slip: 34575

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By
D2000109S	10	14G	n/a	✓	HR
D2000111S	10	14G.	n/a.	✓	HR

7/11/07

S6

Notes:

2 Boxes.

Material Certification Attached: yes

REFERENCE C